

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025068**Date Inspected:** 06-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** An Qing Xiang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the Self-Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

OBG TA YARD, SEGMENT 13AE

This QA Inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated MT report for this date. The members are identified as OBG Components. The weld designations reviewed are as follows.

OBE13B-013

BLAST SHOP 2, OBG 14W

This QA Inspector performed Blast inspection on base metal, fillet welds and complete joint penetration (CJP) welds from panel point (PP) 125 to PP 126 on internal surface of floor beam, vertical shear plate and bottom panel of OBG segment 14W at cable side section and FL2 area. During inspection, several non conforming discontinuities such as weld spatter, deep gouges, arc strikes and improper temporary attachment removal were observed. These areas were marked up for repair. At one location PP 125.5 (E) weld joint (CJP with steel backing) joining web plate of FB 3318B to LD 3048A, the gap between steel backing bar and web plate is

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

observed approx 5mm to 7mm and backing bar observed as tack welded. All information regarding this marked on weld map and submitted to Lead QA Inspector. See attached photos for additional information.

This QA Inspector observed the following work in progress:

OBG Seg 13BE

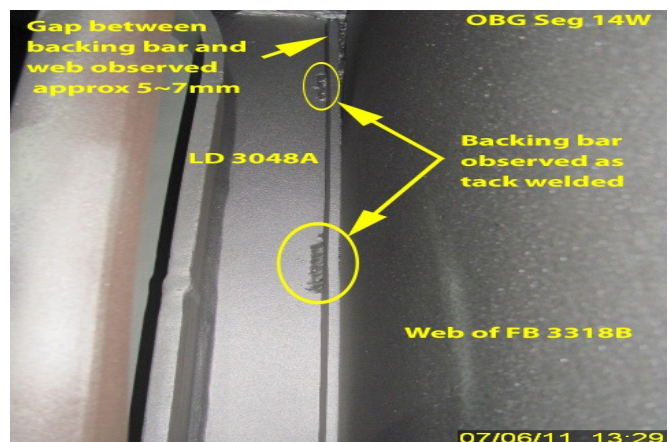
This QA Inspector observed ZPMC qualified welding personnel identified as 068097 perform welding by Shielded Metal Arc Welding (SMAW) process. Weld joint is identified as SEG3009C-219, 220. ZPMC Quality Control (QC) Inspector identified as Zhong Yong Gang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2114-FCM-1.

This QA Inspector observed ZPMC qualified welding personnel identified as 067764 perform welding by SMAW process. Weld joint is identified as SEG3009C-225. ZPMC Quality Control (QC) Inspector identified as Zhong Yong Gang was present to monitor the welding process. The welding variables recorded by ZPMC QC appeared to be in general compliance with WPS-B-P-2113-FCM-1.

OBG Seg 13AE

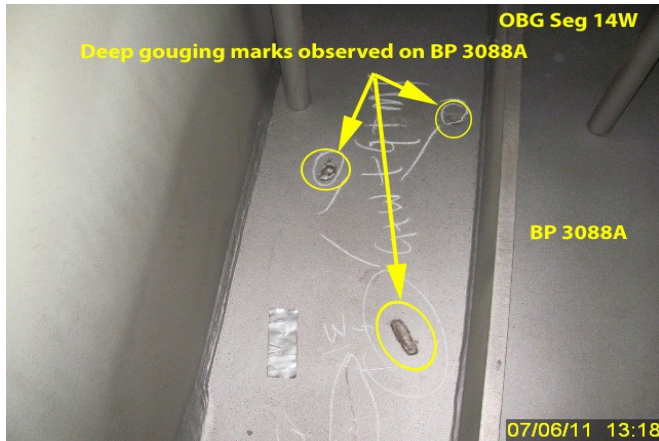
During random in process inspection this QA Inspector observed that ZPMC personnel performing base metal repair on the side panel SP3070A and SP3071C of segment 13AE. The welder is identified as 069118 and performing welding by SMAW process. ZPMC QC was identified as Mr. Li Peng Fei. See attached photograph for more details.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang : 15000422372, who represents the Office of Structural Materials for your project.

Inspected By: Gaikwad,Umesh

Quality Assurance Inspector

Reviewed By: Peterson,Art

QA Reviewer